

Date: Wednesday, 31/01/2007 1:41:20 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D407-667-205
Job Number : 30541	
Estimate Number : 10804	
P.O. Number :	Part Number : D407667205
This Issue : 31/01/2007 S.O. No. :	Drawing Number : HA1
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LANDING GEAR	Drawing Revision :
Previous Run : 29269	Material :
Written By : _____	Due Date : 07/02/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

Additional Product

Job Number:

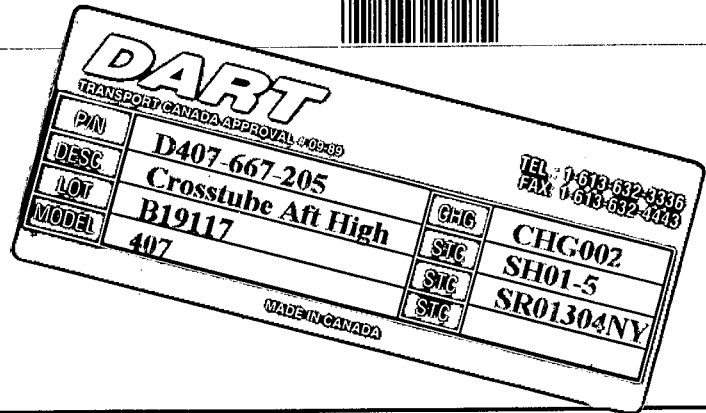


Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
REMOVE FROM STOCK
D407-667-205
RECORD B/N



2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1
REMOVE CLAMPS MS21920-22 (4 PLACES)
REMOVE CLAMPS MS21920-24 (2 PLACES)
DISCARD CLAMPS

IT 07-02-01

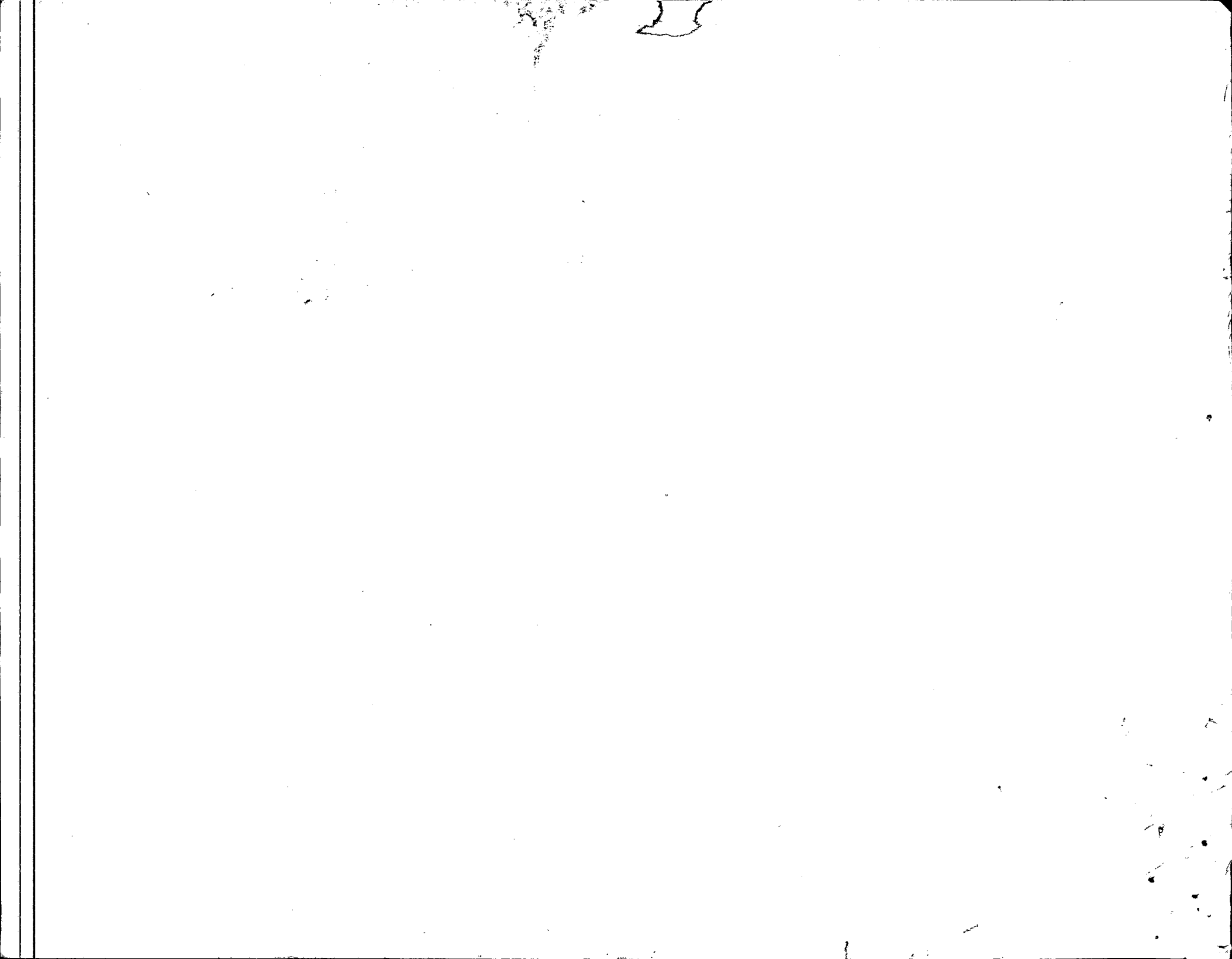
3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
REMOVE D3190-1 CHAFING SHIELDS (2 PLACES)
REMOVE D2894-1 SUPPORT (1 PLACE)
KEEP FOR REINSTALL

IT 07-02-01

REMOVE D2856-400 AND D2856-600 ABRASION STRIP
AND DISCARD



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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 30541

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2070201

5.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

RE-PAINT/ TOUCH UP SECTION OF CROSSTUBE
AS REQUIRED PER QSI 005 4.2.2

ml 070306

①

6.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

2070206
let to be sit. 2070307 ①

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

INSTALL SUPPORT D2894-1 PER DRWG D407-667-245

USING MAGNOBOND 6398 B M102437

ENSURING B/N MATCHES CROSSTUBE

new support 618008

REPLACE CLAMPS

2 X MS21920-24 B M103001 DP7-2-6

ADD RUBBER CUSHION

2 X D2182B (D2182B) B M103275

2070207 TURN over

USED M-NE080-S-125
Neoprene sheet 80 durometer
0.125 thick (4.3" long
0.875" wide)

***RECHECK LOCATION OF SUPPORT ON
CROSSTUBE 30 MINS AFTER INSTALLING *****

INSTALL ABRASION STRIP D2856-400-773 (2 PLACES)
AS PER DRWG D407-667-245

DP7-2-6 B29285

INSTALL D3190-1 CHAFING SHIELDS (2PLACES)
AND MS21920-22 CLAMPS M102389 DP7-2-6
AS PER DRWG D407-667-245

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2070207 ①



Date: Wednesday, 31/01/2007 1:41:20 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 30541

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC6

DIMENSIONAL CHECK



20702-07 @



Comment: DIMENSIONAL CHECK

10.0

PACKAGING 1

PACKAGING RESOURCE #1



NEW CHG # 4



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP

Ensure DSI is attached

2/3/7

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/07/03/07

Job Completion



L Lacelle

From: Dan Stow [dstow@dartaero.com]
Sent: January 31, 2007 8:56 AM
To: 'Linda Lacelle'
Subject: 407 aft crosstube for HAI

Linda,

Please create a W/O to update the support installation on the 407 crosstube for HAI

Step:

- 1 - Remove D407-667-205 from stock
- 2 - Remove clamps MS21920-22 clamps (4 places)
Remove clamps MS21920-24 clamps (2 places)
DISCARD CLAMPS
- 3 - Remove D3190-1 Chafing Shields (2 places)
Remove D2894-1 Support (1 place)
KEEP FOR REINSTALL
- 4 - Remove D2856-400-773 abrasion strips (2 places)
Remove D2856-600-851 abrasion strip (1 place)
DISCARD ABRASION STRIPS
- 5 - Touchup paint as required per QSI 005.4.2.2
- 6 - Inspect level 14
- 7 - Locate D2894-1 Support on crosstube as per dwg D407-667-245
- 8 - Bond D2894-1 Support to crosstube using
Magnobond 6398 = =
MS21920-24 clamps
D2182B rubber cushion
RECHECK LOCATION OF SUPPORT ON CROSSTUBE BEFORE 30 MINS AFTER INSTALLATION
- 9 - Install Abrasion Strip D2856-400-773 (2 places) as per dwg D407-667-245
- 10- Install D3190-1 Chafing Shields (2 places) as per dwg D407-667-245
MS21920-22 clamps (4 places)
- 11- inspect level 5 and 6

Thanks
Dan

31/01/2007

Dan Stow
Technical Support
Dart Aerospace
Tel: 613.632.3336
Cell: 613.676.0992
dstow@dartaero.com
www.dartaero.com

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: ~~2092~~ 30541

Part Number: D407667205

Job Number: [REDACTED]

REFERENCE ONLY

Seq. #:

Machine Or Operation:

Description:

23.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

B29107

25

07-02-03

24.0

D28941

2.750 Support



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2894-1

Support

25.0

D31901

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3190-1

Chafing Shield

26.0

MS20601AD4W8



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

14100771

25

07-02-03

27.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

28.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 MS21920-24

Clamp



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: ~~30541~~ 30541

Part Number: D407667205

Job Number: ~~30541~~

REFERENCE ONLY

Seq. #: Machine Or Operation: Description :

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

17.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D407-667-245

18.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

19.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

20.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3524 f(s)/Unit Total : 1.3524 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

21.0

D2856600

Abrasion Strip



Comment: Qty.: 0.7445 f(s)/Unit Total : 0.7445 f(s)

Pick:

Qty Part number Description Batch

1 D2856-600(8.510") Abrasion Strip

22.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate B28382

07-02-03



DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D407-667-245	REV. C SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH AFT)	SCALE NTS
A	02.05.13	NEW ISSUE	
B	03.05.21	ADD CHAFING SHIELD	
C	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

Qty	Part Number	Description
X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
1	D6011-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
1	D2856-600-851	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
1	D2894-1	SUPPORT
2	D3190-1	CHAFING SHIELD
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-22	CLAMP
2	MS21920-24	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6011-115
FINISHED LENGTH = 112.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 / D2856-600-851 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2894-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT (OPTIONAL).
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.
- 13) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.

UNDER REVIEW

06.06.23 CB

update dwg PH
continue mfg 07.02.02**UNDER REVIEW**

06.07.10 PH

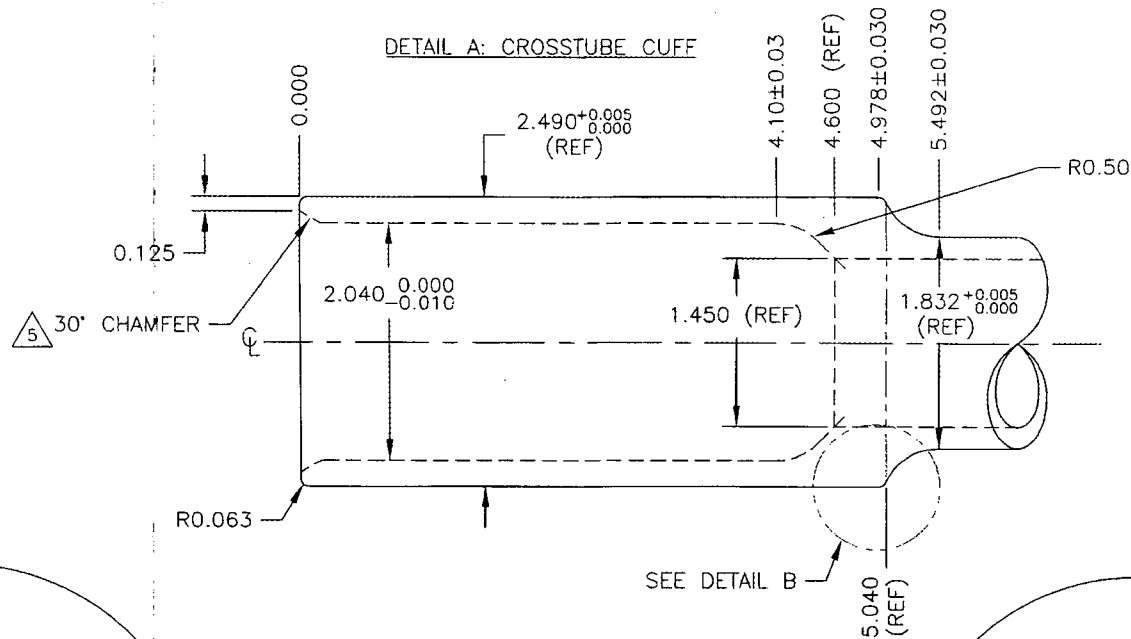
re-draw Detail B

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WITHOUT NOTICE
WORK ORDER
NO. 30541

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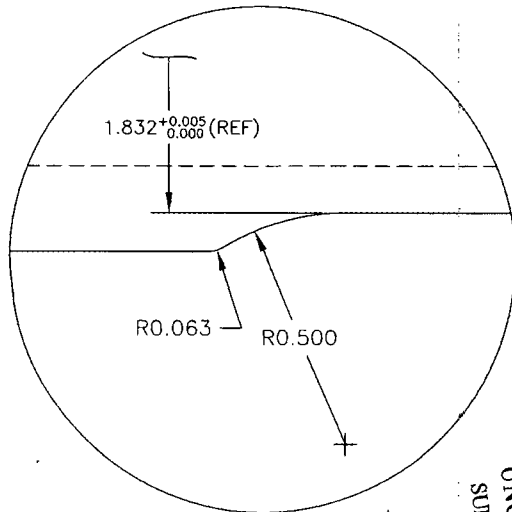
DETAIL A: CROSSTUBE CUFF



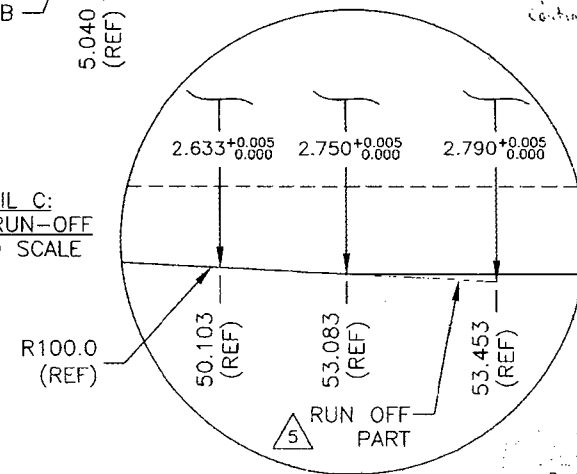
PH
07.02.02
UNDER REVIEW
06.08.10 PH
re-draw detail b

UNDER REVIEW
06.08.23 CB
update dw
continues to go

DETAIL B: CUFF TRANSITION SCALE 4:1



DETAIL C: TAPER RUN-OFF NOT TO SCALE



05.07.26

NO. 30541
WORK ORDER
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DART AEROSPACE LTD.

DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED IDS	APPROVED IDS	DRAWING NO. D407-667-245	REV. C SHEET 3 OF 3
DATE 05.07.26	TITLE CROSSTUBE ASS'Y (407 HIGH AFT)	SCALE 1:1	

Tuesday, 06/03/2007 11:51:15 AM

Linda Lacelle

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	D407-667-205
Job Number :	30541		
Estimate Number :	10804		
P.O. Number :		Part Number :	D407667205
This Issue :	06/03/2007	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	HAI
First Issue :	31/01/2007	Project Number :	
Previous Run :	29269	Drawing Revision :	
		Material :	
Written By :		Due Date :	07/02/2007
Checked & Approved By :		Qty:	1
Comment :		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

REMOVE FROM STOCK

D407-667-205

RECORD B/N

019117 RT 07-02-01

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

REMOVE CLAMPS MS21920-22 (4 PLACES)

REMOVE CLAMPS MS21920-24 (2 PLACES)

DISCARD CLAMPS

RT 07 02 02

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

REMOVE D3190-1 CHAFING SHIELDS (2 PLACES)

REMOVE D2894-1 SUPPORT (1 PLACE)

KEEP FOR REINSTALL

REMOVE D2856-400 AND D2856-600 ABRASION STRIP RT 07 - 02 - 02
AND DISCARD

Tuesday, 06/03/2007 11:51:15 AM

Linda Lacelle

Process Sheet

Date: / /
User: / /

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 30541

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

RE-PAINT/ TOUCH UP SECTION OF CROSSTUBE
AS REQUIRED PER QSI 005 4.2.2

ml 070

6.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

INSTALL SUPPORT D2894-1 PER DRWG D407-667-245

USING MAGNOBOND 6398 B 102437

ENSURING B/N MATCHES CROSSTUBE

Support 18008

REPLACE CLAMPS

2 X MS21920-24 B 103004 RT 07-02-03

ADD RUBBER CUSHION

2 X D2182B (D2182B) B ~~102437~~

***RECHECK LOCATION OF SUPPORT ON

CROSSTUBE 30 MINS AFTER INSTALLING *****

INSTALL ABRASION STRIP D2856-400-773 (2 PLACES)

AS PER DRWG D407-667-245

INSTALL D3190-1 CHAFING SHIELDS (2 PLACES)

AND MS21920-22 CLAMPS 102389

AS PER DRWG D407-667-245

RT 07-02-03

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Date: Tuesday, 06/03/2007 11:51:15 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 30541

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Date: Tuesday, 06/03/2007 11:46:34 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 30541	Customer	: Dart Aerospace Ltd.
Estimate Number	: 10804	DWG Name	: D407-667-205
Purchase Order #	:	Part Number	: D407667205
Complete Date	: / / : : AM	DWG Number	: HAI
		Rev.	:

DUE DATE	ORDERED	DELIVERED
07/02/2007	1	0

2.0 LANDING GEAR 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
01/02/2007	TITL01: Titley, Ian	Run	0.000	0.75	\$11.83	0.75	15.00

Subtotal: QTD: 0 CTD: 0 0.75 \$26.83

3.0 LANDING GEAR 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
02/02/2007	TITL01: Titley, Ian	Run	1.000	0.22	\$3.47	0.22	4.40
03/02/2007	TITL01: Titley, Ian	Run	0.000	0.00	\$0.00	1.93	38.60
03/02/2007	TITL01: Titley, Ian	Run	1.000	1.93	\$0.00	0.00	0.00
05/02/2007	TITL01: Titley, Ian	Run	1.000	1.68	\$26.49	1.68	33.60

PROVR

Subtotal: QTD: 3 CTD: 0 3.83 \$106.56

5.0 SPRAY PAINTING Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
02/02/2007	MURD02: Murdoch, Matthew	Run	0.000	0.34	\$5.25	1.36	99.28

Subtotal: QTD: 0 CTD: 0 0.34 \$104.53

7.0 LANDING GEAR 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
06/02/2007	PAQU03: Paquette, Dan	Run	0.000	5.25	\$82.79	5.25	105.00
07/02/2007	TITL01: Titley, Ian	Run	1.000	8.15	\$128.53	8.15	163.00
07/02/2007	TITL01: Titley, Ian	Run	0.000	0.50	\$7.89	0.50	10.00

Subtotal: QTD: 1 CTD: 0 13.90 \$497.21

	TIME	COST
Machine Time:	19.84	\$468.88
Labor:	18.82	
Sub-contract (External Op.):		
INVENTORY ITEM:		
SUB-COMPONENT (SUB-JOB):		
Total:		

CROSSTUBE AFT HIGH

P/N: D407-667-205

CHG002

R/N: B19117

COST PER UNIT:

Date: Wednesday, 07/03/2007 8:46:10 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 30541

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D28941

2.750 Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
2.750 Support

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

13.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: 1101340 ✓

14.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
Batch: 1100564 ✓

15.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick: Packing Kit
Qty Part number Description Batch
10 AN5-10A Bolt 1102083 ✓

CPA 03/07/07

Date: Wednesday, 07/03/2007 8:46:10 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 30541

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

M14781 (3X) M103287 (1X)

17.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M102929

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP

NEC 7/3/07

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.03.07